

Date: Tuesday, 1/8/2008 1:18:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L BASKET LID
 Job Number : 36654B
 Estimate Number : 11274
 P.O. Number : Part Number : D2252043
 This Issue : 1/8/2008 S.O. No. : Drawing Number : D2252 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 35657B Material :
 Written By : Due Date : 1/31/2008 Qty: 1 Um: Each
 Checked & Approved By : 08.01.08
 Comment : Est Rev: REVISED AS PER REV E 05-12-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M108063

SAD 08/06/11

(1)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

SAD 08/06/11

(1)

3.0 D2329 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2329 Label Plate

M35686

FC 08 06 12

4.0 D23271 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing

M36920

FC 08 06 12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/8/2008 1:18:18 PM
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Drawing Name: 206L BASKET LID

Job Number: 36654B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B35684

FC 08 06 12

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

D39046

FC 08 06 12

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M107966

FC 08 06 12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch:

M105524 FC

M107051

SS 08/06/12
FC 08 06 12

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-16

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/16

11.0

POWDER COATING

POWDER COATING




Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

WE/FL 08/06/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/06/17	11.0	<u>1st Coat</u> start time: 7:40 Temperature: 400° finish time: 8:10	<u>2nd Coat</u> 8:25 400° 8:55	FZ WZ	08/06/17		 08/06/17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/8/2008 1:18:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 36654B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/17 @

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

08/06/17 @

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/19

Job Completion



U 08-06-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



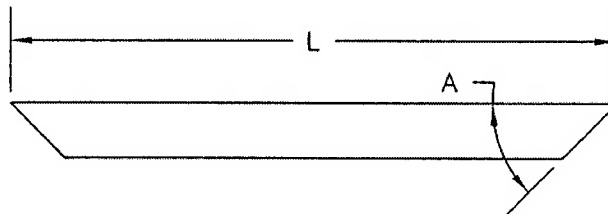
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CHECKED #	APPROVED #	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

RELEASED
05.11.26 #

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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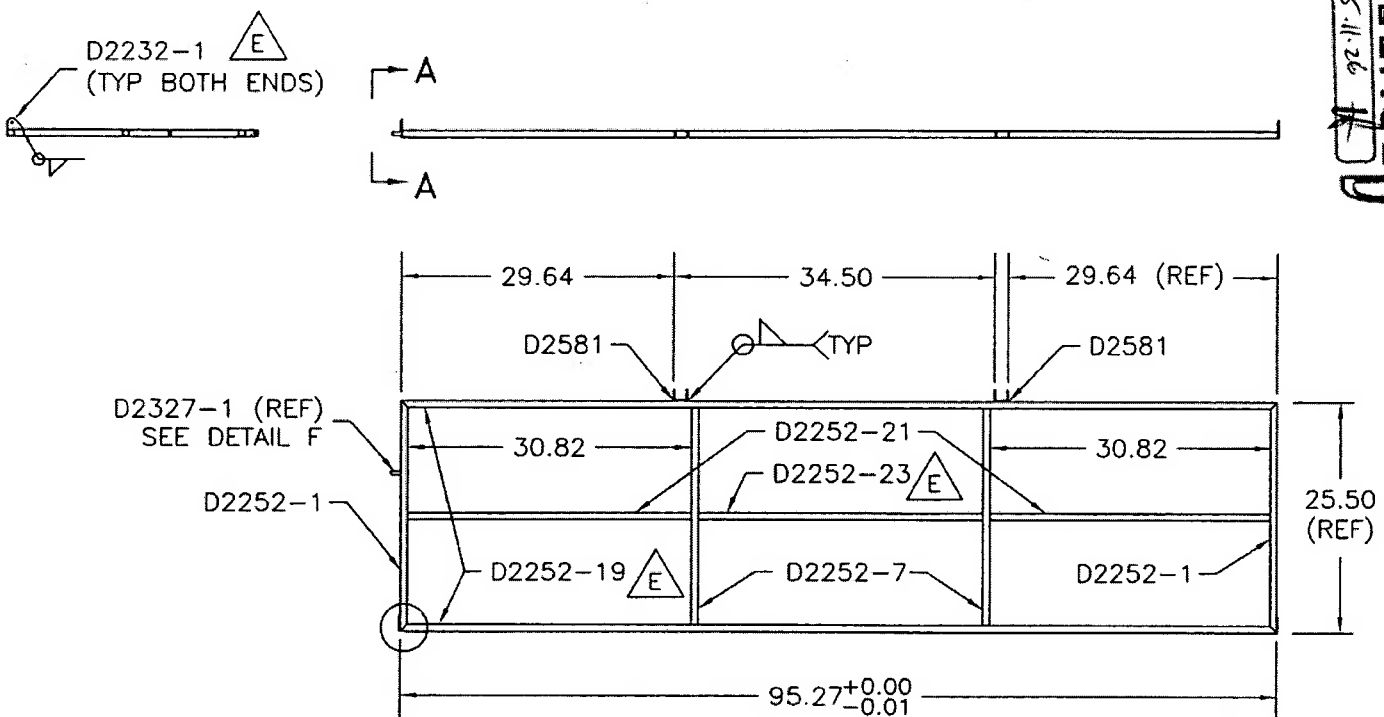
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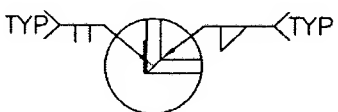


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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE N15		

RELEASED
05-11-26



D2252-043 LID FRAME



WELD ALL JOINTS
AS SHOWN

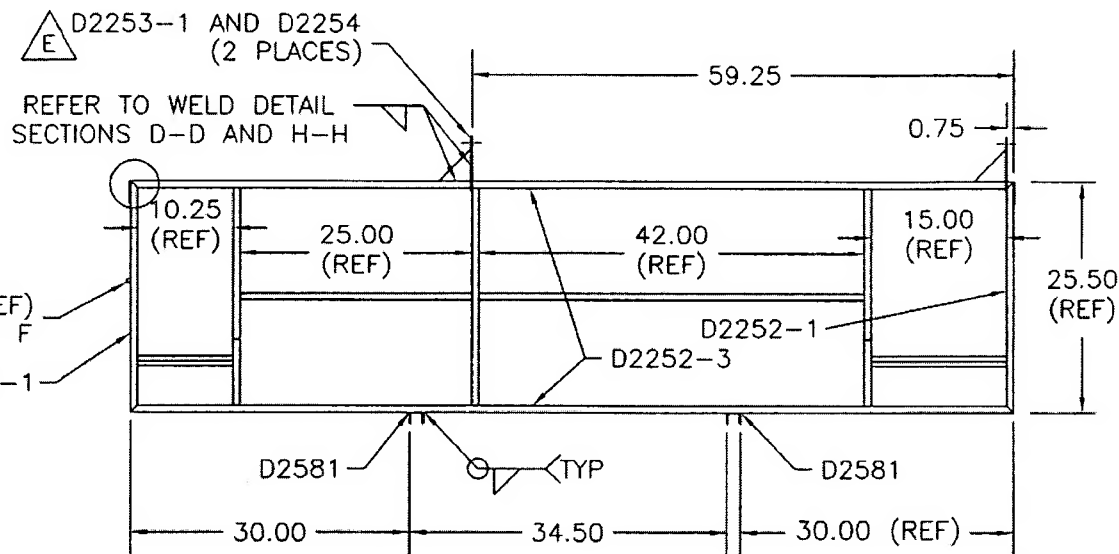
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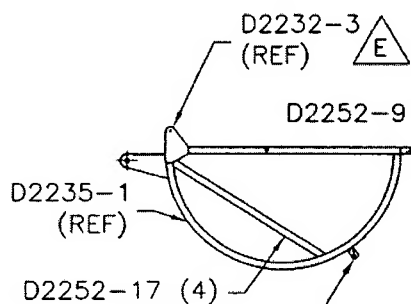
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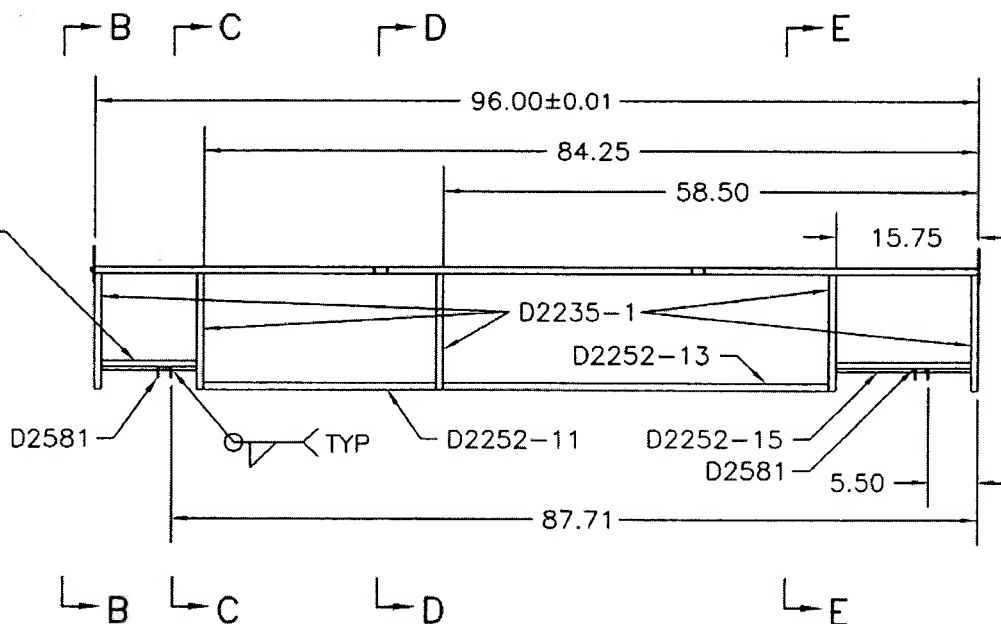
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KE	MB	DRAWING NO.	REV. E	
CHECKED	APPROVED	D2252	SHEET 3 OF 5	
DATE	TITLE	BASKET ASSEMBLY (206L)	SCALE	
05.11.10			NTS	



WELD ALL JOINTS
AS SHOWN



WELD D2581
WITH LARGE HOLE
ON THIS SIDE



D2252-041 BASKET FRAME

RELEASED
05/11/26

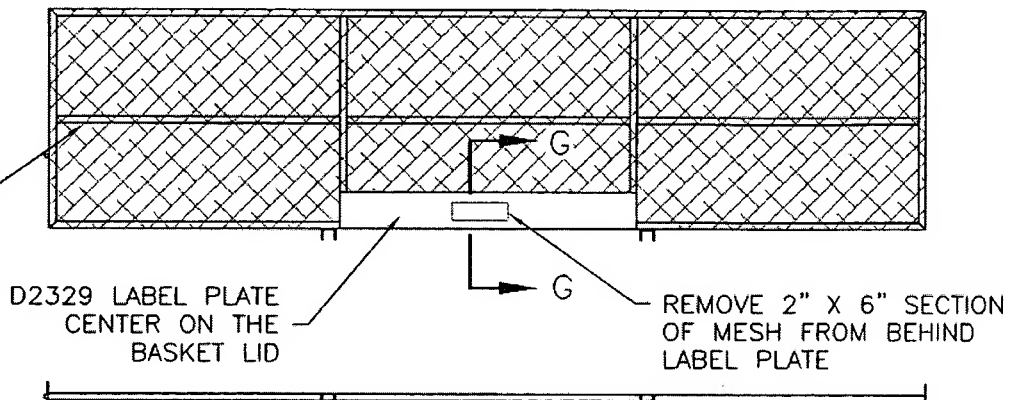
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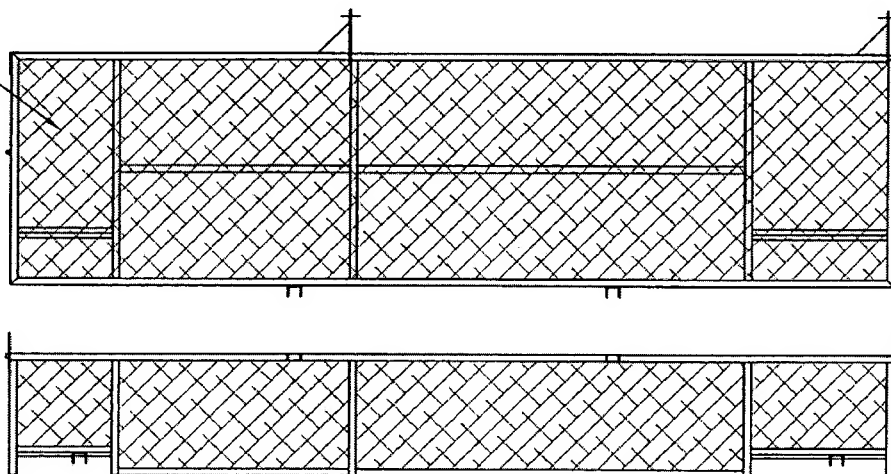
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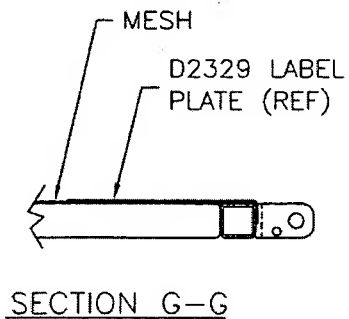
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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5
		SCALE	NIS	



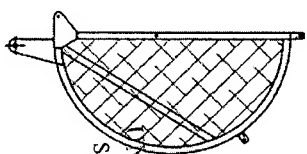
D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

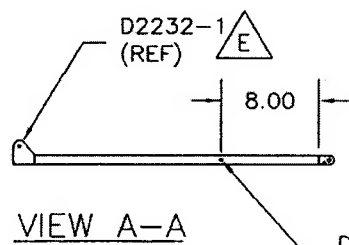
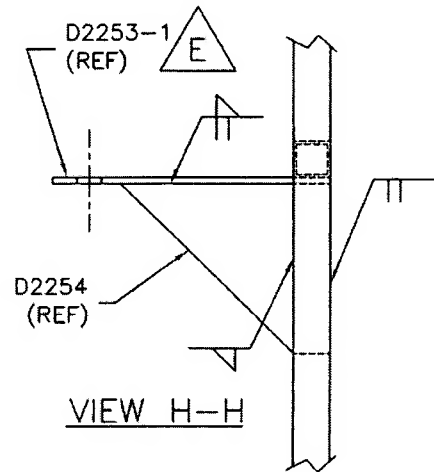
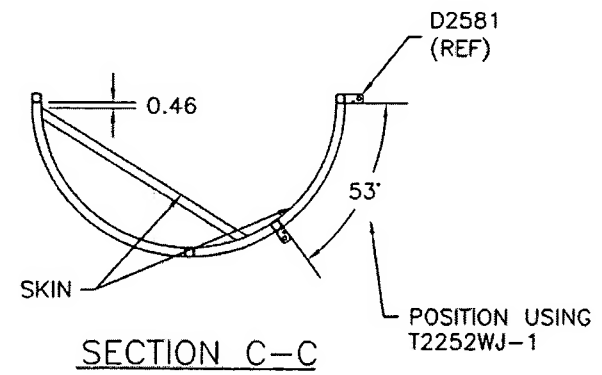
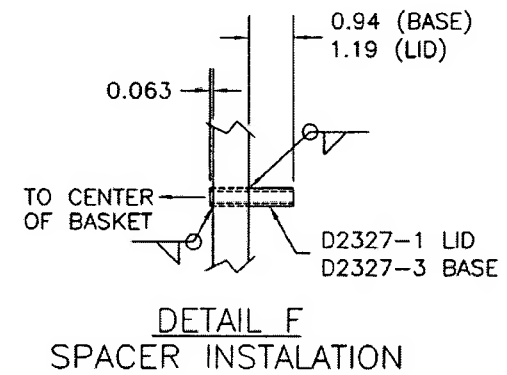
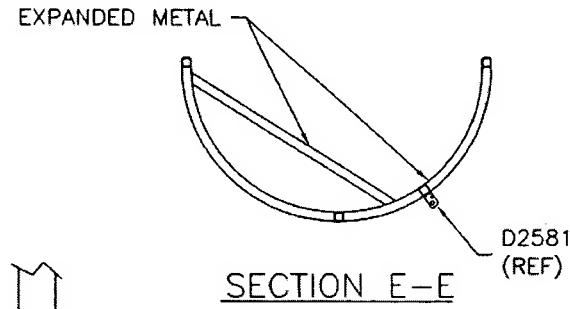


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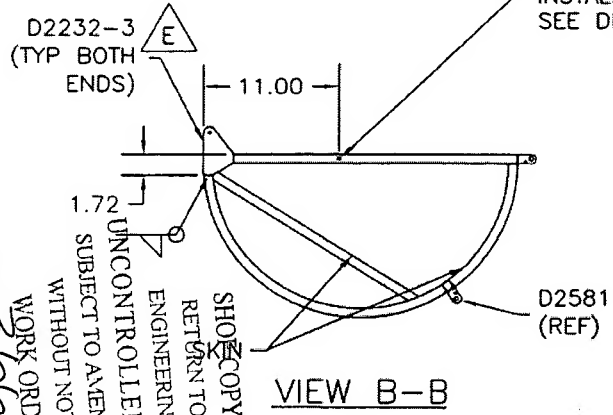
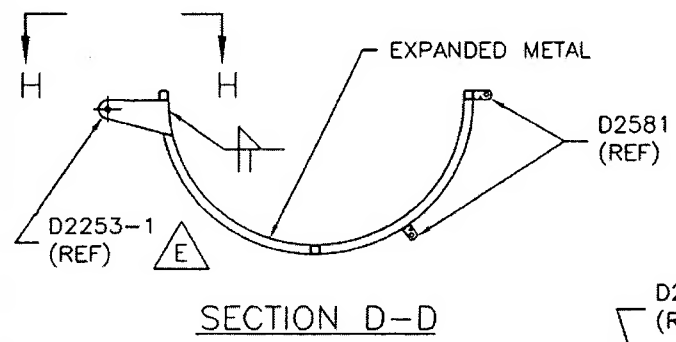
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	REV. E SHEET 5 OF 5
		SCALE MKS



DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL F



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